

# Work Order ID 65685

January 21, 2011 2:24:45 PM

Page 1

Item ID: D4278-041

Accept

Revision ID:

Item Name: Upper Rib Assembly-Hoop

Start Date: 1/21/11

Start Qty: 1.00

Required Date: 1/26/11

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4278

C

100

Weld per dwg A/R S.S. rod Batch: 111585

0.00

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT

2- Weld bushing in rib and grind weld flush as per dwg

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*Cpl 11-01-27*

*(3x)*

*11-01-27*

*(3)*

*BEU/01/27*

*Sublet*

*(3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65685

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Page 2

Item ID: D4278-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Upper Rib Assembly-Hoop

Start Date: 1/21/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: WP

0.00



Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN BASKET CELL\*\*\*

SAD  
11-01-22

3

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/31 *[Signature]*

C21101/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 21, 2011 2:24:44 PM

Page 1

Work Order ID: 65685

Parent Item: D4278-041

Parent Item Name: Upper Rib Assembly-Hoop

Start Date: 1/21/11

Required Date: 1/26/11

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

396

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-7 Hoop		Manufactured	No			100	Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				10					
				58039				1					
				64260				2					
				65309				7					
D4021-9 Bushing		Manufactured	No			100	Each	9.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				9					
				56094				2					
				63854				7					
D4034-1 Rib		Manufactured	No			100	Each	9.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				9					
				64169				3					
				65310				6					
D4034-3 Rib		Manufactured	No			100	Each	0.0000	1	1			

Cpl 11.01.27

3

Cpl 11.01.27

B65303 → 9

3

Cpl 11.01.27

3

B65665 → 3 Cpl 11.01.27

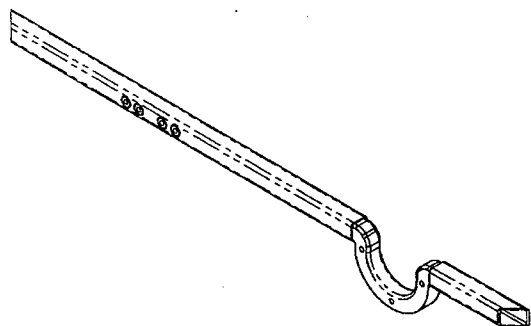
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

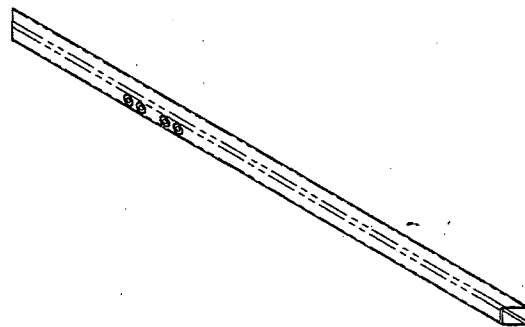
**NOTE:** Date & initial all entries



**D4278-041 UPPER RIB ASSY-HOOP**



**D4278-045 RIB ASSY, FWD CHAM**



**D4278-047 UPPER RIB ASSY-STRAIGHT**

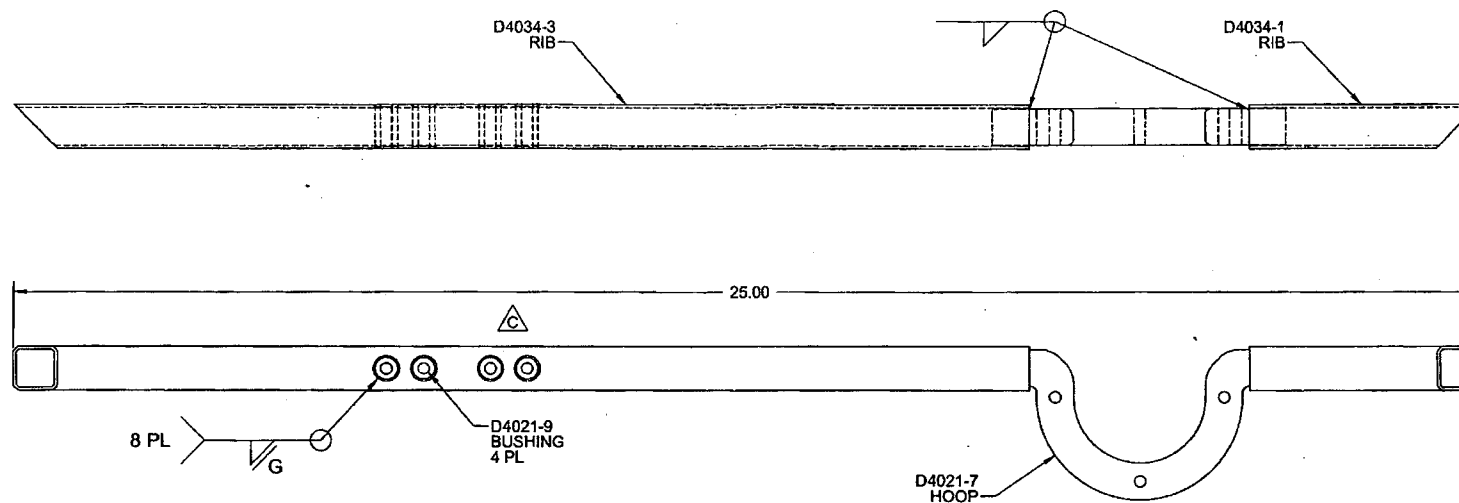


**RELEASED**  
R 2011-01-18  
M

*W/ob 5/6/5*

C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4278</b>	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



**D4278-041 UPPER RIB ASSY-HOOP**

**RELEASED**  
2011-01-18

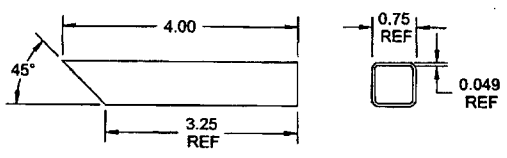
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

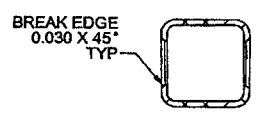
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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4278</b>	SHEET 2 OF 4
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DE APPR.		<b>RIB ASSEMBLY</b>	NTS
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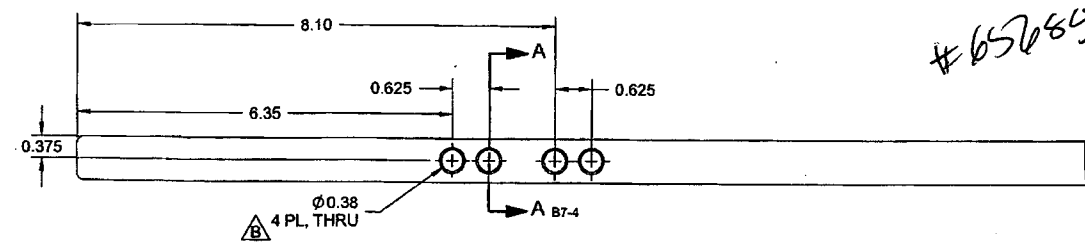
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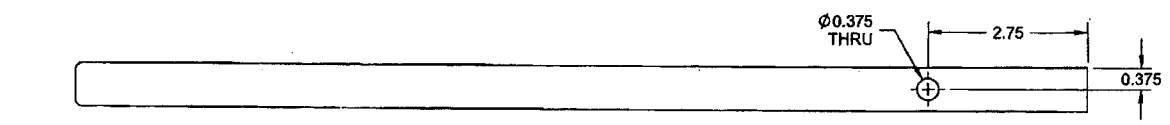
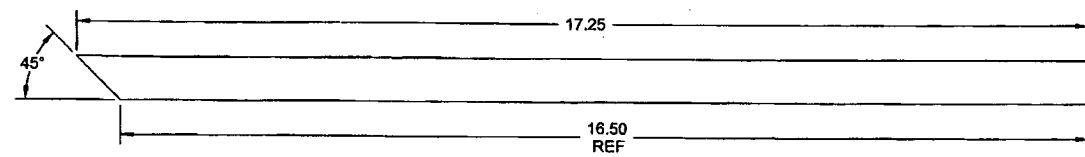
**D4034-1 RIB**



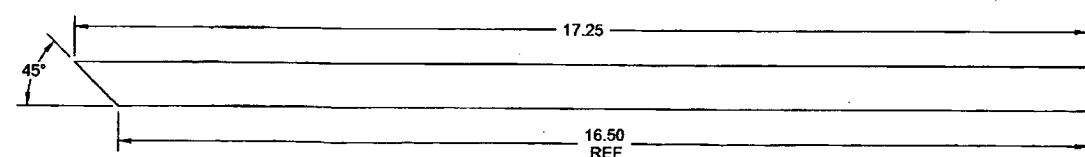
**SECTION A-A D4-4**



**D4034-3 RIB**



**D4034-5 RIB**



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT -1: 0.13 lbs  
-3 & -5: 0.62 lbs

**RELEASED**  
2011-01-10

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	K	DRAWING NO.	REV. B
MFG. APPR.	W	D4034	SHEET 4 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	W	UPPER RIB ASSY, BASKET BASE	NTS
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